

Work Order ID 50441

September 22, 2009 10:58:16 AM

Page 1

Item ID: D3121-041

Accept

Revision ID: E

Item Name: Bracket Assembly

Setup Start

Stop

Start Date: 7/15/09 Start Qty: 12.00

Required Date: 7/15/09 Req'd Qty: 12.00

Cust Item ID:

Customer:

Reference:

Handwritten: 09.09.22

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3121

Rev E

100

0.00



BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blanks: (1.000" x 2.000") 3.250" long

Handwritten: on 09/09/28

Handwritten: 12

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Machine D3121-11 as per Folio FA331 and Dwg D3121 Identify as D3121-11; 2-Deburr; 3-Scribe batch number

Handwritten: SL / 09/10/03

Handwritten: PTO →

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

Handwritten: SL

Handwritten: mje / 09/10/03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3121-041 PAR #: Fault Category: Machined parts NCR: Yes No DQA: Date: 05.10.13
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: Date: 05.10.13

NCR: <u>50441</u> -1		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09/09/30	1/0	- Spacing dimension of the bottom slot of .300 are off from .240 to .365	<u>[Signature]</u>	- modify jaws for proper alignment & using. - Scrap & replace qty 3	<u>SL</u> 09/09/30	<u>815</u> 09/10/05	<u>[Signature]</u>	<u>[Signature]</u> 05-10-05
		SC couldn't align jaws properly to fit good on the part, jaws were pulling the part when tightening	<u>[Signature]</u>				<u>[Signature]</u>	<u>[Signature]</u> 05-10-05
		RC: Tooling wear & tear.	<u>[Signature]</u>					

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D 3121-041 PAR #: _____ Fault Category: Prod - Machined parts NCR: Yes No DQA: / Date: 05.10.13
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: / Date: 05.10.13

NCR: 50441		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09/10/12	110	2 parts dimension of the bottom slot .300 dia .282 and .00330. Parts got push out of place because face mill feed too quickly. Parts popped in vise. R.C. process.	<u>/</u>	change feed in program for proper speed of cutting scrap. replace M111787 qty 2.	<u>mt</u> 09/10/12	<u>/</u> 09/10/05	<u>/</u>	<u>/</u>

NOTE: Date & initial all entries

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Item ID: D3121-041

Accept



Setup Start



Revision ID: E

Item Name: Bracket Assembly

Stop



Start Date: 7/15/09 Start Qty: 12.00



Cust Item ID:

Required Date: 7/15/09 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

88 09/10/03

12

140

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

Assemble D3121-141 as per Dwg D3121.

88 09/10/05 (12)

150

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

88 09/10/05

(12) 4

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Item ID: D3121-041

Accept



Setup Start



Revision ID: E

Stop



Item Name: Bracket Assembly

Start Date: 7/15/09 Start Qty: 12.00



Cust Item ID:

Required Date: 7/15/09 Req'd Qty: 12.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

Identify as per dwg & Stock Location: 235

0.00



Packaging

Memo

0.00

Packaging

9/10/5 (12x) SB

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/10/06 fjt
mf 09-10-05

Picklist Print

September 22, 2009 10:58:16 AM

Page 1

Work Order ID: 50441

Parent Item: D3121-041RevE

Parent Item Name: Bracket Assembly



Comments:

Start Date: 7/15/09

Required Date: 7/15/09

Start Qty: 12.00



Required Qty: 12.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3121-21RevE		Manufactured	No			140	Each	57.0000	12.0000			
												
Bolt												

Ep 09/10/05

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	57	
46032	17	
50096	40	



2
10

D3121-241RevE		Manufactured	No			100	Each	34.0000	12.0000			
												
Bearing Assembly												

Ep 09/10/05

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	34	
46169	34	

12

M174B1.250X02.000		Purchased	No			140	f	28.5600	3.4168			
												
17-4 SS Bar 1.250 x 2.00												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	28.56	
109851	4.56	
111787	24	

3.25
mf 09/09/28

DART AEROSPACE LTD		Work Order:	50441
Description: Bracket		Part Number:	D3121-11
Inspection Dwg: D3121 Rev: E		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**
☐ **Prototype**

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.392	+0.002/-0.000	.3925	✓			
Ø0.201 x 0.100	+/-0.010	.196 x .099	✓			
0.75	+/-0.030	.751	✓			
0.375	+/-0.010	.375	✓			
1.250	+/-0.010	1.240	✓			
0.300	+/-0.010	.290	✓			
1.96	+/-0.030	1.960	✓			
Ø0.573	+/-0.010	.574	✓			
0.345	+/-0.010	.345	✓			
0.300	+/-0.010	.300	✓			
0.080	+/-0.010	.080	✓			
2.56	+/-0.030	2.560	✓			
2.14	+/-0.030	2.140	✓			
0.130	+/-0.010	.130	✓			
2.57	+/-0.030	2.570	✓			
2.85	+/-0.030	2.850	✓			
0.381	+/-0.010	.385	✓			
0.400	+/-0.010	.396	✓			
0.201	+/-0.010	.199	✓			
0.580	+/-0.010	.582	✓			
0.032	+0.000/-0.010	.024	✓			

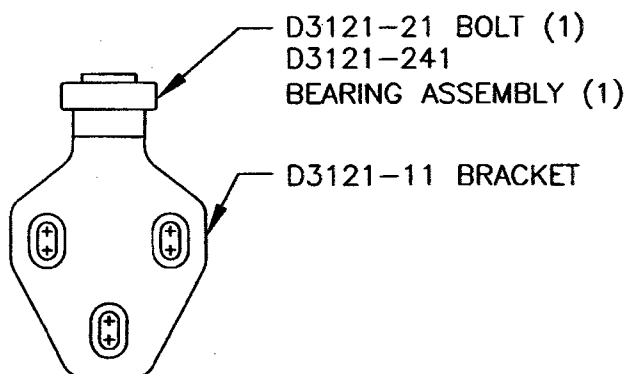
Measured by:	JL	Audited by:		Prototype Approval:	N/A
Date:	09/09/29	Date:		Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.02.01	New Issue P/O D3121-041	KJ/EC/DD	
B	08.06.02	Tolerance revised for Ø0.573	KJ/DD	JA

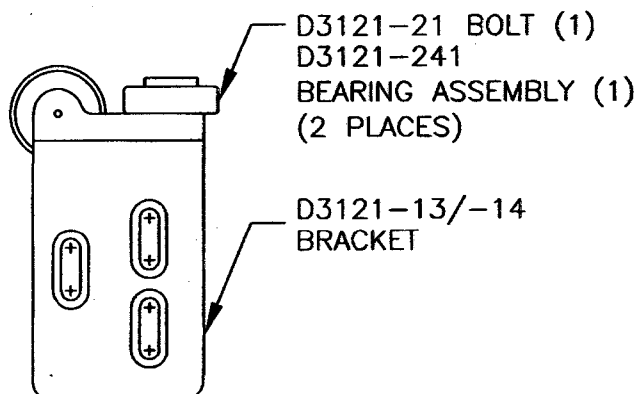


DESIGN #	DRAWN BY LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3121	REV. E SHEET 1 OF 10
DATE 07.11.07		TITLE BRACKET ASSEMBLY	SCALE 1:2
A	02.04.15	NEW ISSUE	
B	03.01.16	ADD RIDGES; ADD MAT'L PROP; FIX P/N ADD -141/-143/-144/-145/-146	
C	04.02.17	ADD CLEARANCE; USE -241 BEARING	
D	06.05.17	D3121-25 CAP WAS 1.024, NOW 1.000	
E	07.11.07	ADD TOLERANCE TO 0.032 (DETAIL B)	

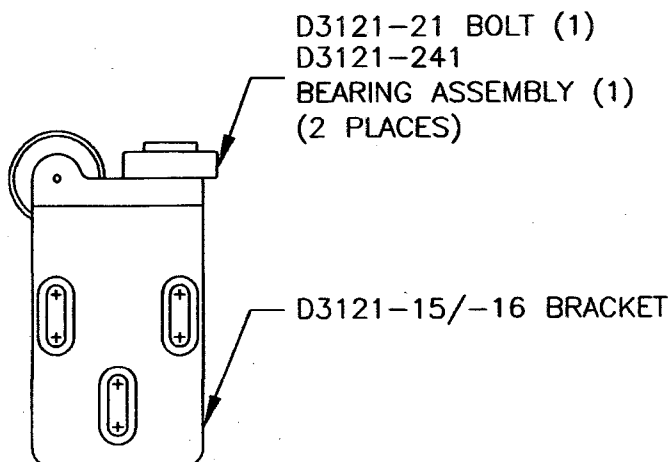
RELEASED
07.11.07



D3121-041 BRACKET ASSEMBLY
(REPLACES PREMIER P/N B30-23000-33)



D3121-043 (SHOWN) / D3121-044 (OPPOSITE) BRACKET ASSEMBLY
(REPLACES PREMIER P/N B30-23000-37/-38)



D3121-045 (SHOWN) / D3121-046 (OPPOSITE) BRACKET ASSEMBLY
(REPLACES PREMIER P/N B30-23000-35/-36)

504711

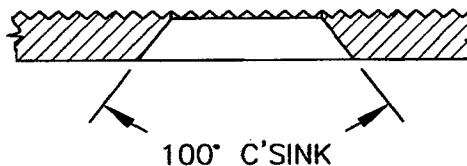
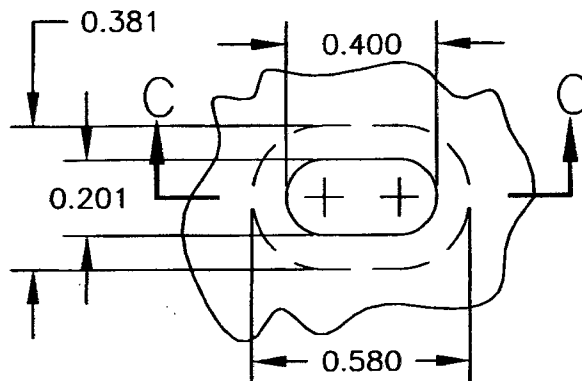
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DESIGN #	DRAWN BY LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3121	REV. E SHEET 3 OF 10
DATE 07.11.07		TITLE BRACKET ASSEMBLY	SCALE 1:1

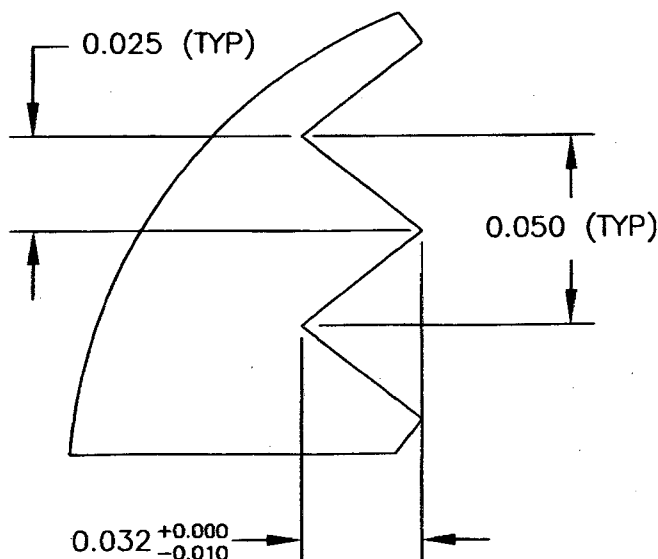
DETAIL A:
SLOT DETAIL
SCALE 2:1
VIEW ROTATED



SECTION
C-C

RELEASED
07.11.07

DETAIL B:
RIDGE DETAIL
PARTIAL SECTION
SCALE 1:20

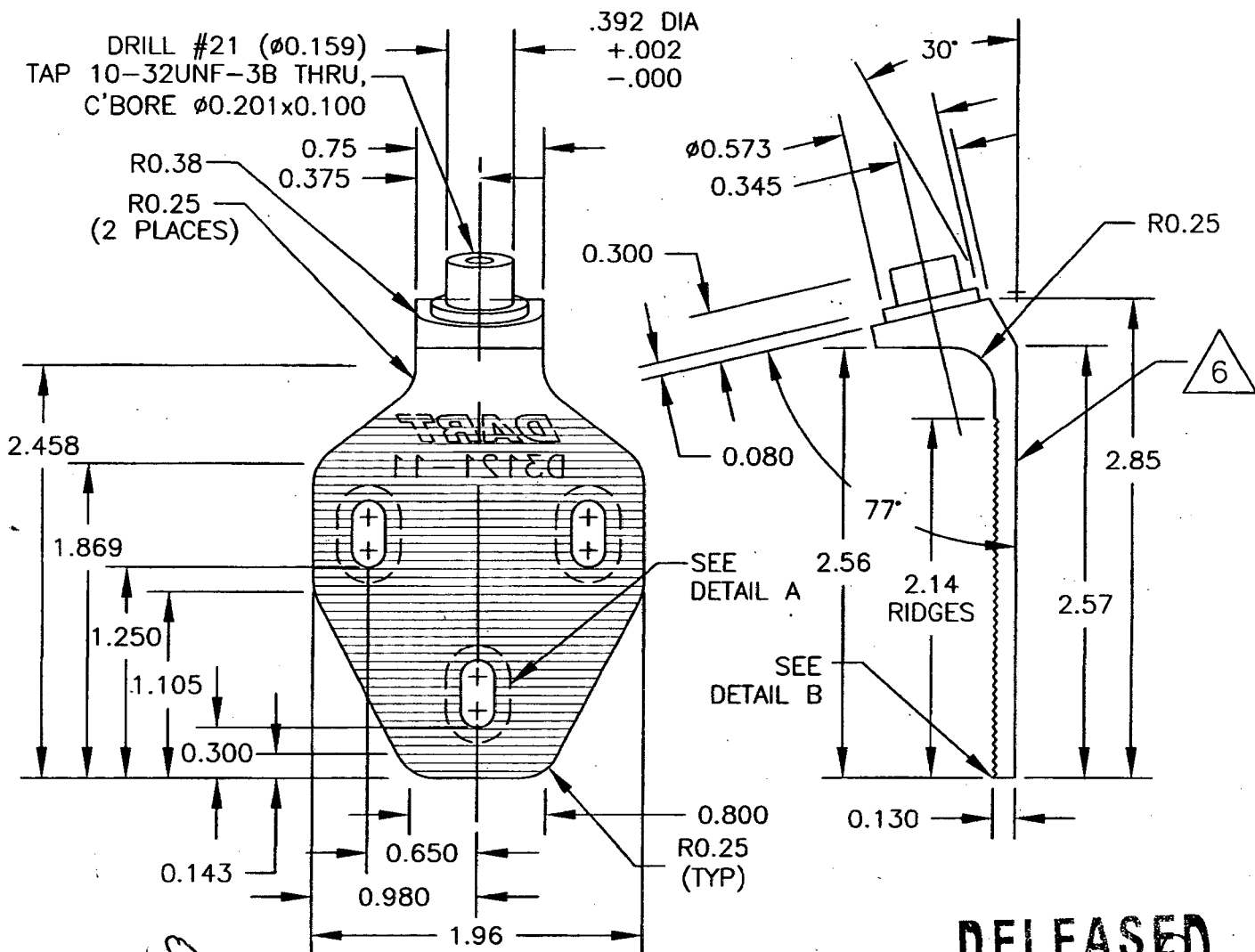


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DART

DESIGN #1	DRAWN BY LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #1	APPROVED #1	DRAWING NO. D3121	REV. E SHEET 4 OF 10
DATE 07.11.07		TITLE BRACKET ASSEMBLY	SCALE 1:1

**RELEASED**
07.11.07**D3121-11 BRACKET**

- 1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)
MIN ULTIMATE TENSILE = 150 ksi
MIN YIELD TENSILE = 100 ksi
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) ENGRAVE DART P/N & LOGO AS SHOWN
- 6) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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